

Work Order ID 61241

Wednesday, August 11, 2010 11:35:03 AM



Page 1

Item ID: D3535-15

Accept



Setup Start



Revision ID:

Item Name: Wearshoe

Stop



Start Date: 8/12/2010 Start Qty: 10.00



Cust Item ID:

Required Date: 8/26/2010 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan: *[Signature]*

Date: 10-8-17

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3535

Rev B

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3535 ☐ Dwg Rev: B ☐ Prog Rev: B ☐ 2-
Deburr if necessary

304 .040

10-8-17

13

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

10-8-17

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

10/06/17

13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Stop



Start Date: 8/12/2010 Start Qty: 10.00



Cust Item ID:

Required Date: 8/26/2010 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	NC BRAKE	0.00							
Brake NC	Memo	0.00							
Brake NC	1-Form on Brake as per Dwg D3535 using Jigs DT8261 and DT8326 2-Form joggle as per Dwg D3535 using Jig DT8158 3-Identify as D3535-15								
140 	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									
150 	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3	0.00							
Powdercoat	Memo	0.00							
Powder Coating	START TIME: 11:30 OVEN TEMPERATURE: 320 FINISH TIME: 12:00								

EP 10/08/18 13

13 1005-13

13 BR 10 8-23,

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Page 3

Item ID:	D3535-15	Accept		Setup	Start	
Revision ID:						
Item Name:	Wearshoe				Stop	
Start Date:	8/12/2010	Start Qty:	10.00		Cust Item ID:	
Required Date:	8/26/2010	Req'd Qty:	10.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160  QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00		7M 10/08/23		113	0		
170  Packaging Packaging	Identify as per dwg & Stock Location: <u>FP-18</u> Memo	0.00 0.00		M 10/08/23		113	0		
180  QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							10/08/23  mf 10-8-23

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Picklist Print

Wednesday, August 11, 2010 11:35:02 AM

Page 1

Work Order ID: 61241



Parent Item: D3535-15



Parent Item Name: Wearshoe


Start Date: 8/12/2010

Required Date: 8/26/2010

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:A New Issue 07-02-15 JLM
IPP Rev:B As per Rev B 07-08-31 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S20GA  304/316 .040 Sheet		Purchased	No			100	sf	19.5987	1.0205	10.74211			



1210-8-17

Location

Loc Qty

Loc Code

MAT

16.1522

114574

16.1522

MAT20

3.4465

112885

2.7475

113062

0.699

115440

115440

13

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 6241
Description: Wearshoe		Part Number: D3535-15
Inspection Dwg: D3535	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.885	+/-0.010	1.888	x		V HP-02	
2.000	+/-0.010	2.000	o		V	
5.650	+/-0.010	5.650	o		T HD-01	
9.150	+/-0.010	9.150	o		T	
14.400	+/-0.010	14.400	o		T	
19.650	+/-0.010	19.650	o		T	
24.900	+/-0.010	24.900	o		T	
30.150	+/-0.010	30.150	o		T	
33.650	+/-0.010	33.650	o		T	
35.650	+/-0.010	35.650	o		T	
39.150	+/-0.010	39.150	o		T	
Ø0.188	+0.005/-0.001	.190	o		V	
24.00	+/-0.030	24.00	o		T	
16.00	+/-0.030	16.00	o		T	
8.00	+/-0.030	8.00	o		T	
5.00	+/-0.030	5.00	o		T	
0.300	+/-0.010	.301	o		V	
0.300	+/-0.010	.303	o		V	
0.038	+/-0.010	.034	o		V	

Measured by: WB	Audited by: S	Prototype Approval:	N/A
Date: 10-8-17	Date: 10/08/17	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.05.10	New Issue	KJ/JLM	E

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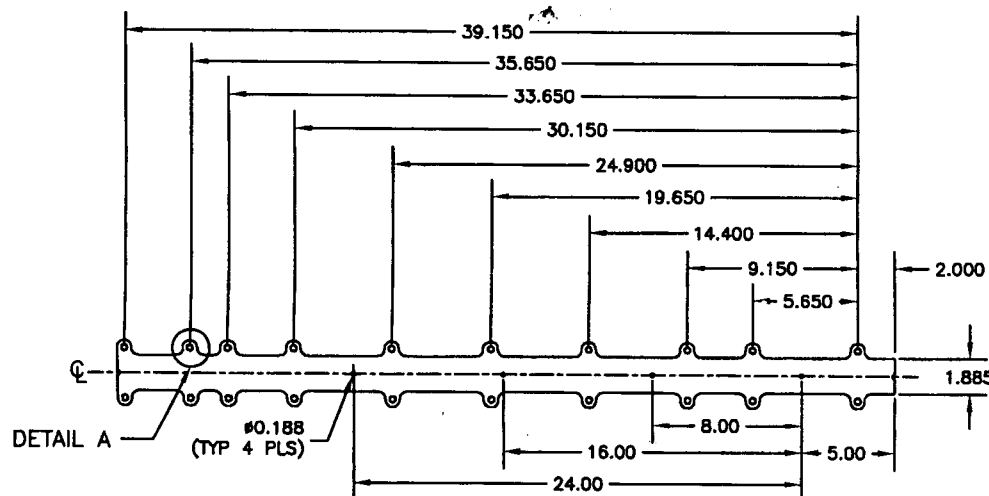
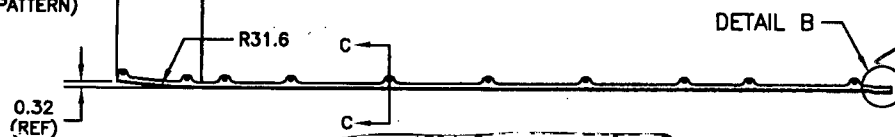
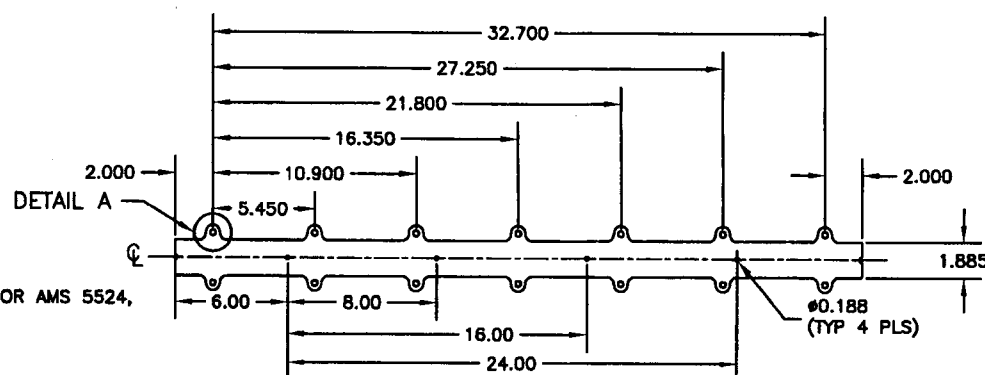
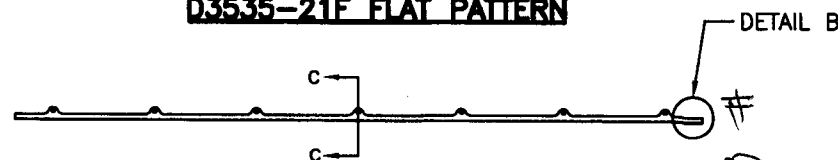
NOTE: Date & initial all entries

DART

RELEASED

07.04.24

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.	
CB	PH	PORT HADLOCK, WA	
CHECKED	APPROVED	DRAWING NO.	REV. B
#	#	D3535	SHEET 2 OF 7
DATE	TITLE	SCALE	
07.04.17	WEARSHOE	1:10	

4.50 TO BEND
LINE (ON FLAT
PATTERN)**D3535-15F FLAT PATTERN****D3535-15 BEND DETAIL****D3535-21F FLAT PATTERN****D3535-21 BEND DETAIL****NOTES**

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT CL
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

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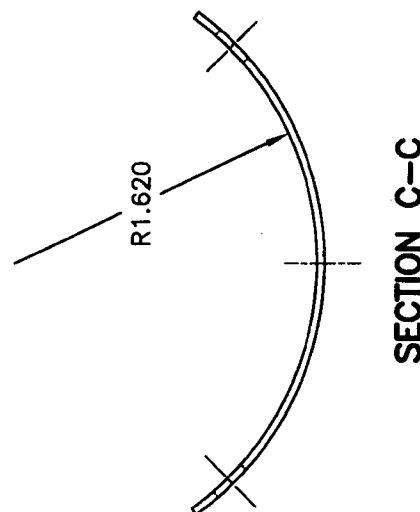
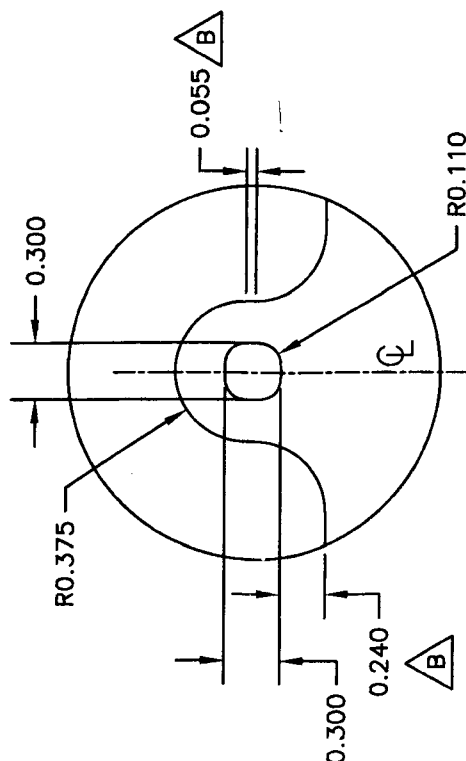
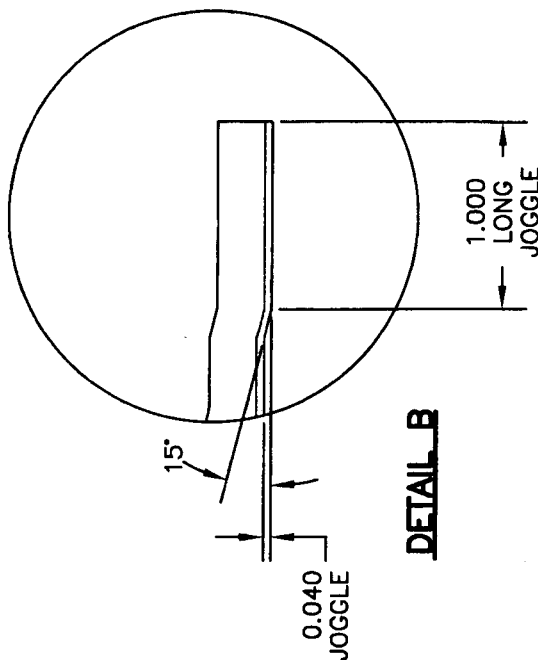


DESIGN CB	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED 	APPROVED 	DRAWING NO. D3535	REV. B SHEET 7 OF 7
DATE 07.04.17		TITLE WEARSHOE	SCALE 1:1

RELEASED

07.04.24

#61241



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